

Page 1



Reference:



Date:

**Insp.
Stamp**

Revision Nbr

Rev A

0.00



MORI SEIKI CNC LATHE LARGE

0.00

, Doosan

Memo

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

0.00

[illegible]

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

0.00.



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

Work Order ID 69650

Page 2

Monday, May 16, 2011 7:41:37 AM

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 5/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

11.5.30

10

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: *CNC*

140

0.00



QC21- Final Inspection - Work Order Release

11/5/30

QC

Memo

0.00

Quality Control

11.05.30
(10)

Picklist Print

Monday, May 16, 2011 7:41:48 AM

Page 1

Work Order ID: 69650

Parent Item: DSK078

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 5/16/2011

Required Date: 5/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-005

Manufactured

No

Each

10.0000

10



20 11.5.30

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

10

68922

10

69676

6 6

4

DART AEROSPACE LTD		Work Order:	69650
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	2.707	2.709	2.709	2.709	2.709	2.709
B	4.946	4.966	4.957	4.957	4.957	4.957	4.957	4.957
C	3.064	3.084	3.075	3.075	3.075	3.075	3.075	3.075
D	0.718	0.738	.725	.725	.725	.725	.725	.725
E	0.090	0.110	.102	.102	.102	.102	.102	.102
F	2.934	2.954	2.945	2.945	2.945	2.945	2.945	2.945
G	2.166	2.186	2.175	2.175	2.175	2.175	2.175	2.175
H	3.890	3.910	3.900	3.900	3.900	3.900	3.900	3.900
I	0.914	0.934	.922	.922	.922	.922	.922	.922
J	0.022	0.042	.032	.032	.032	.032	.032	.032
K	0.109	0.129	.119	.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: [Signature] Date: 11.5.27

Audited by: [Signature] Date: 11.5.27

Prototype Approval: [Signature] Date: [Signature]

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order:	
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
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D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
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I	0.914	0.934		.922	.922	.922	.922	.922
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: 20	Date: 11.5.27
Audited by: 21	Date: 11.5.30
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

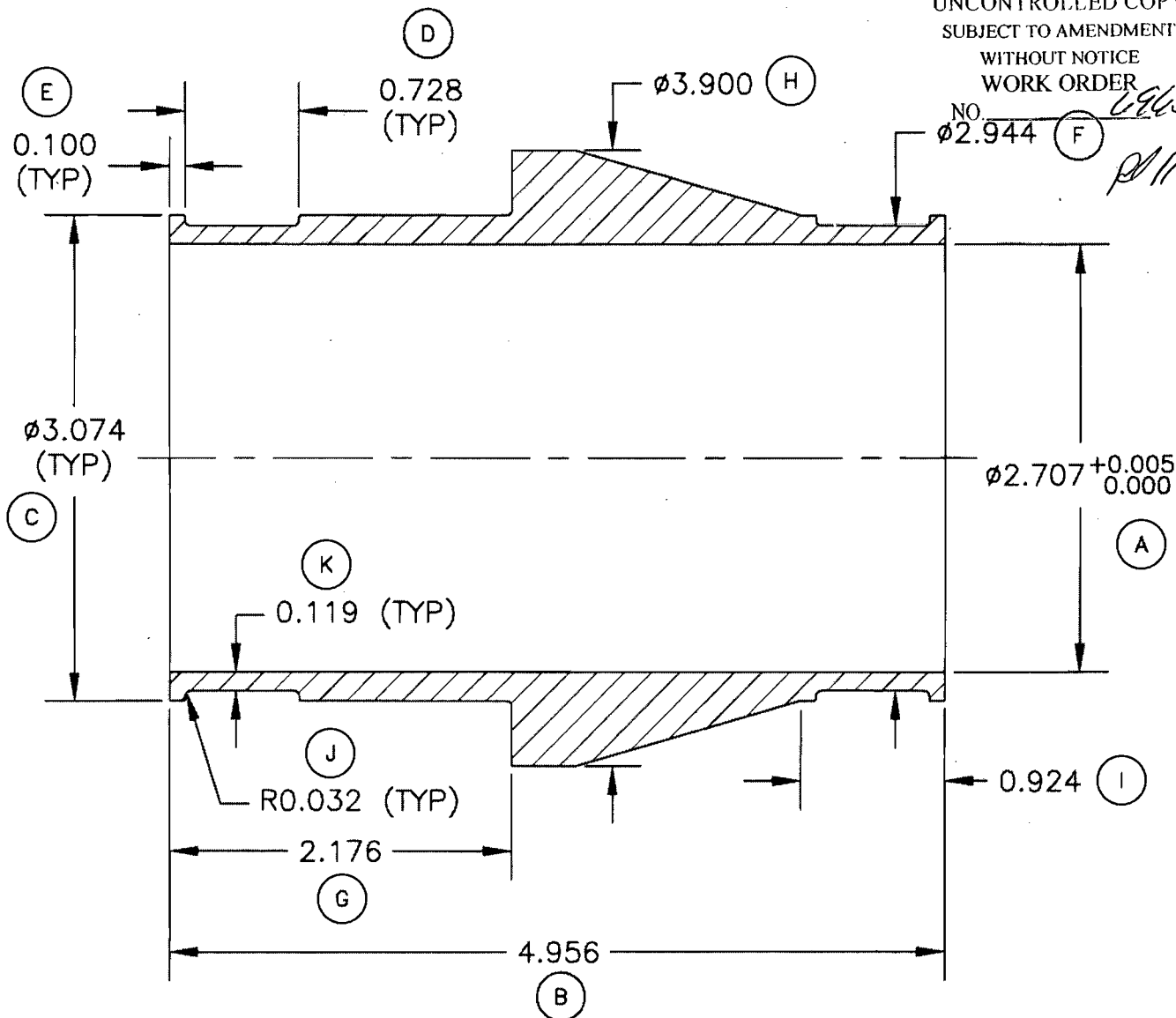


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER

NO. 69650
P/11-05-16



D2893-1 TURNING DETAIL

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